

SPLIT-1

Date: Friday, 5/25/2007 8:36:33 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32643-1
Estimate Number : 12578
P.O. Number : N/A
This Issue : 5/25/2007 S.O. No. : N/A
Prsh't Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 31443
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue: 07.05.24 EC

Drawing Name : ARM
Part Number : D3560041
Drawing Number : D3560 REV.B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 6/5/2007

POSITIVE RECALL

EFFECTIVE 07.06.05 AUTH SP
RELEASED 07.06.06 DATE GP

Qty: 10 30 Unit: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
		Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s) 6061-T6 Bar 0.50" x 5.0" Batch: M17625
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks 16.750" long
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: B 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK

25

WORK ORDER CHANGES

W/O:	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	07.06.06	11	DO NOT POWDER COAT PART. CHEM CONVERSION COAT ONLY. PART WILL BE FINISHED AFTER ASSEMBLY WITH STEP REF ATTACHED DS EMAIL.				UP 07.06.06 per QSI 642	
07.06.06	11	Press Fit Qty 1 D2808 Bushing B 32752 gts 2 +4 FF 07/06/12 B 28600 gts 3						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/06	3	-2 parts are scrapped hole $\phi .507^{+.000}_{-.001}$ are oversize by too much $\phi .510^{\circ} \phi .513^{\circ}$	✓ QSI 642	- Destroy & Replace	J.L. 07/06/06	✓ 07/06/06	✓ QSI 642	✓ 07/06/06

NOTE: Date & initial all entries



Date: Friday, 5/25/2007 8:36:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D35921 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

B32641

PL-07-06-06(5)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL-07-06-07(5)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-06-12
FF 07-06-07

4
5

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

SEE LWD CHANGE

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

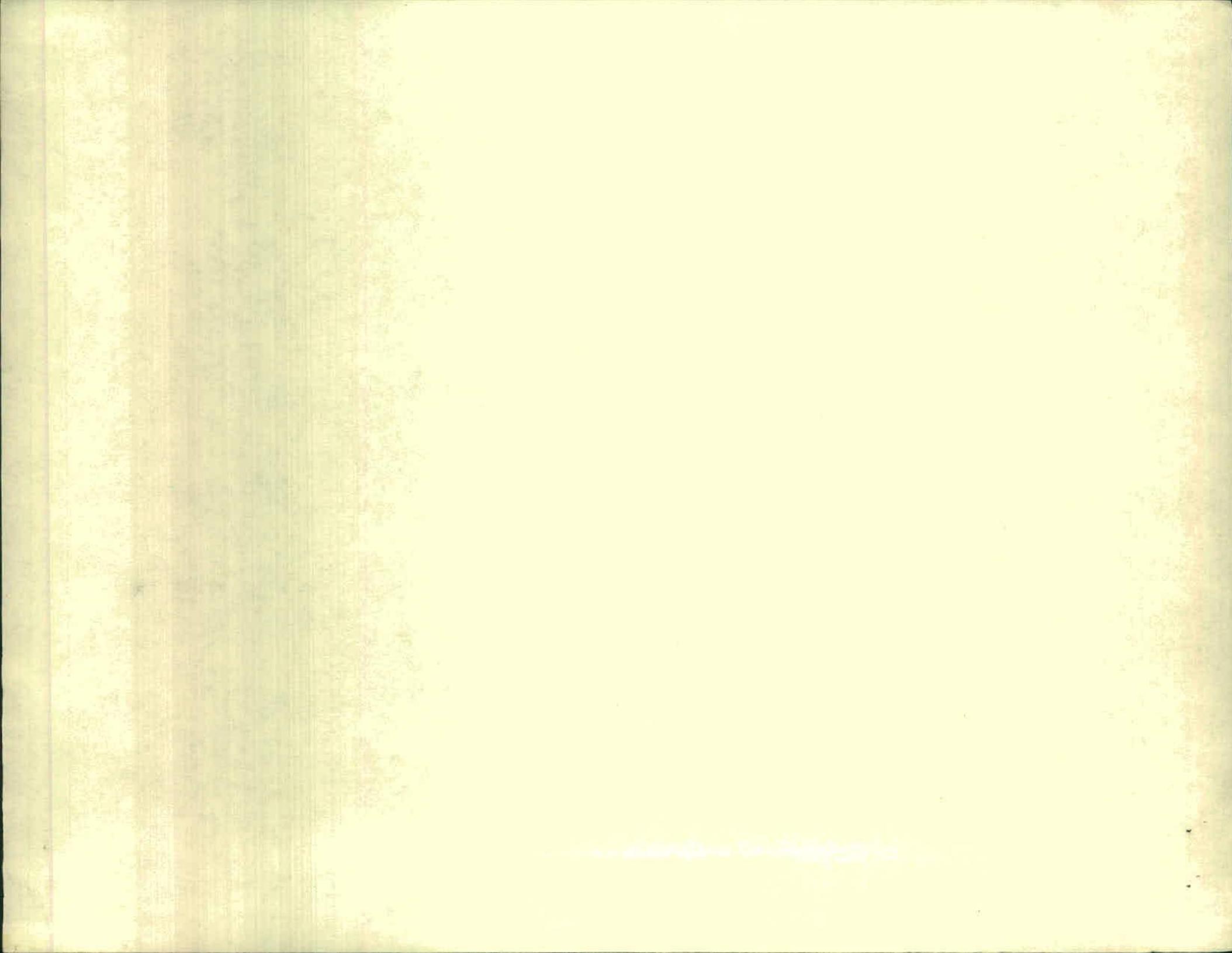
PL-07-06-07(5)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: B7A



Date: Friday, 5/25/2007 8:36:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

5/25/15

6/07/06

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

~~ACTIVE~~

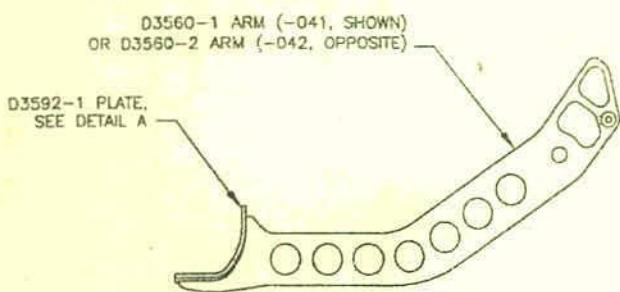
RELEASED

~~DATE~~

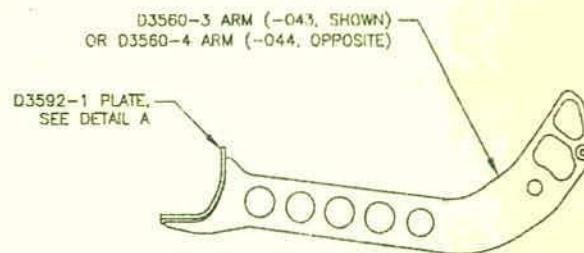
U

5/25/15

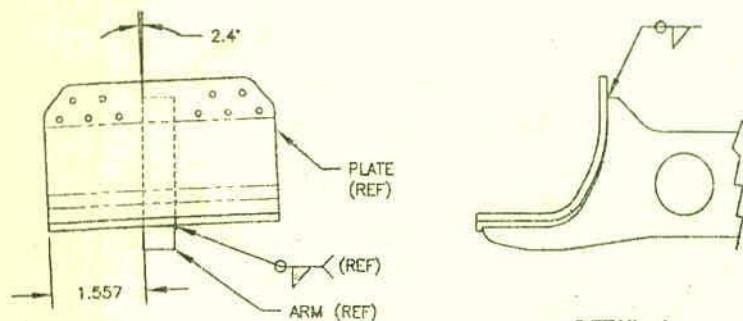




D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07.05.07

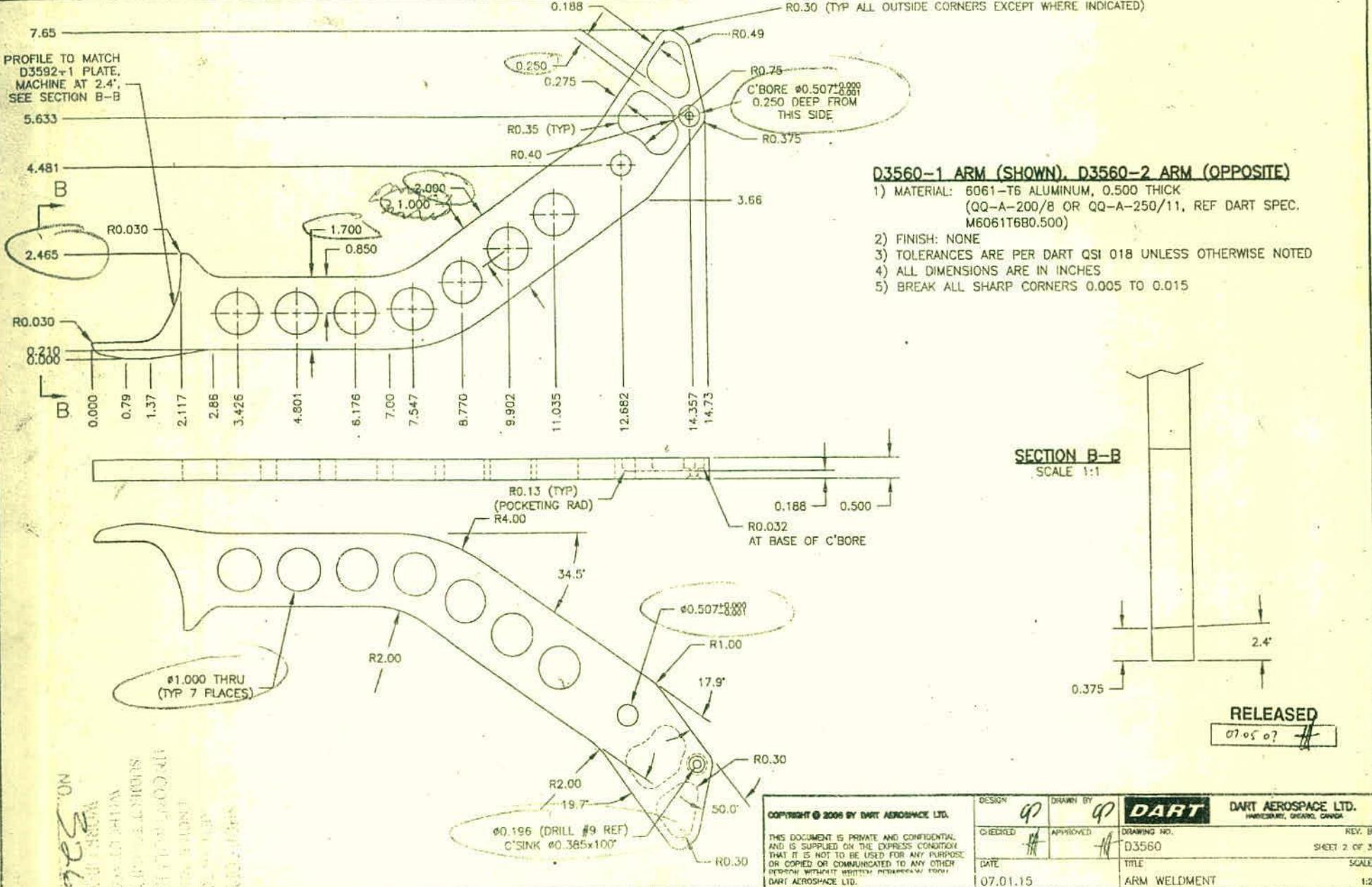
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
DATE		REF. B
07.01.15		SHEET 1 OF 3
		ARM WELDMENT

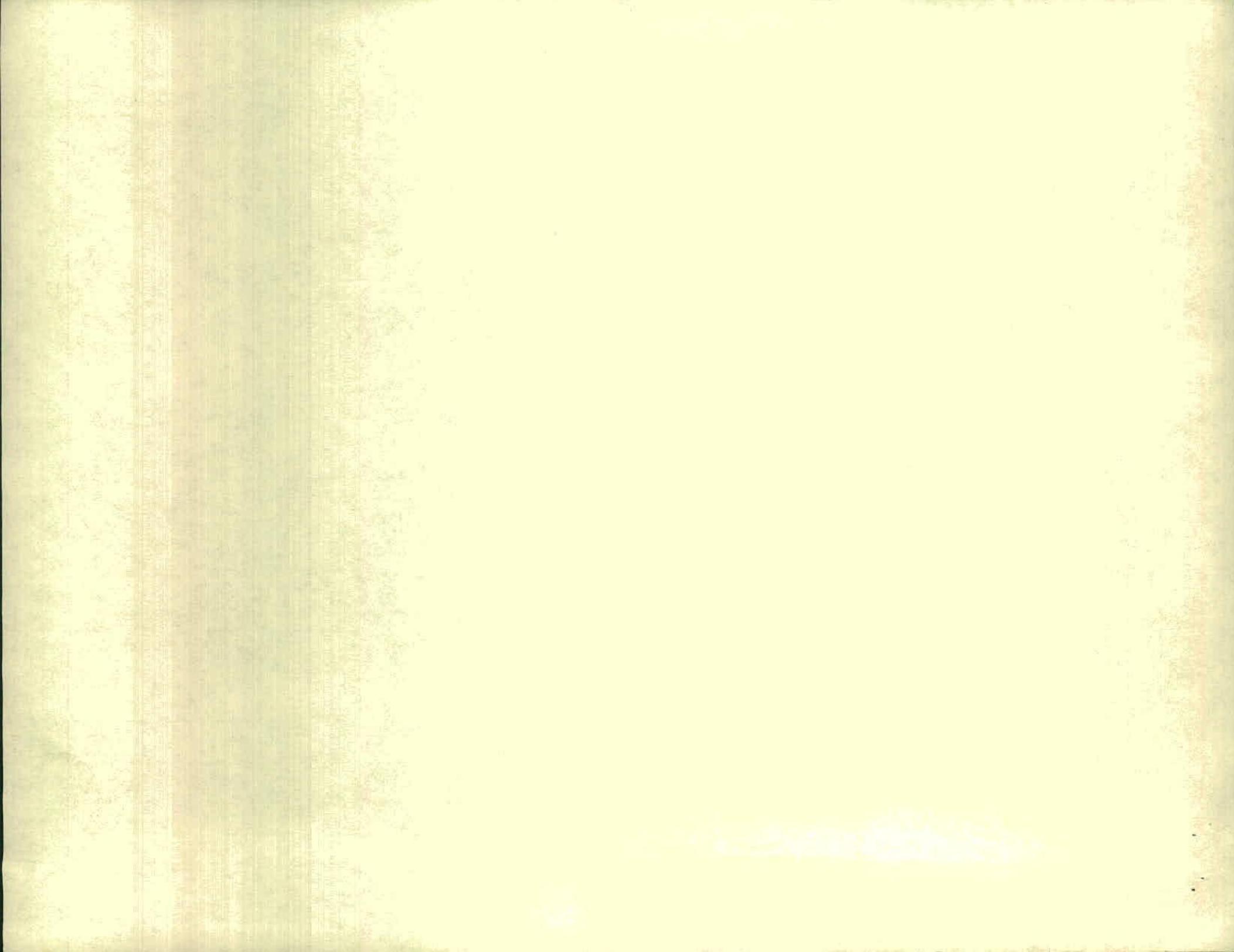
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NO. 264-1
UNCONVENTIONAL
SURFACE
FINISHING
SPECIALISTS
1000 10th Street
P.O. Box 1000
Vancouver, BC V6Z 1L8
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TEL: 604-541-1000
FAX: 604-541-1001

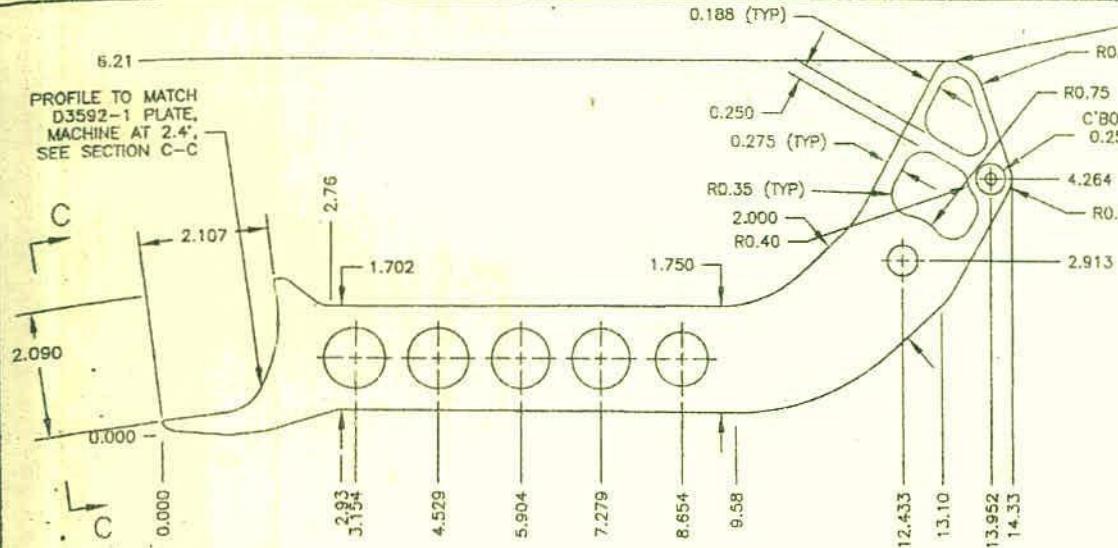






6.21

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4".
SEE SECTION C-C



0.188 (TYP) R0.30 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)

R0.49

R0.75

C'BORE #0.507^{+0.000}
0.250 DEEP FROM
THIS SIDE

4.264

R0.375

R0.35 (TYP)

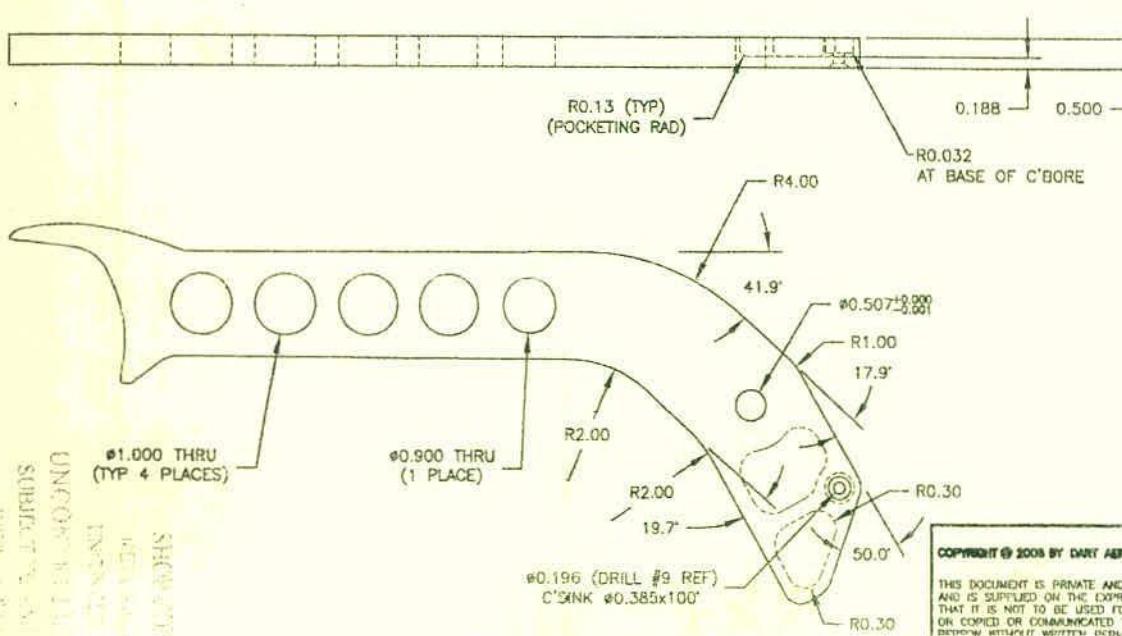
2.000

R0.40

1.750

2.913

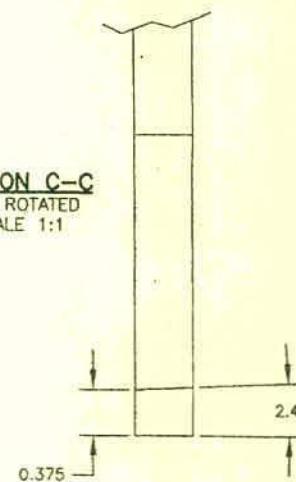
12.433
13.10
13.952
14.33



D3560-3 ARM (SHOWN). D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/B OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION C-C
VIEW ROTATED
SCALE 1:1



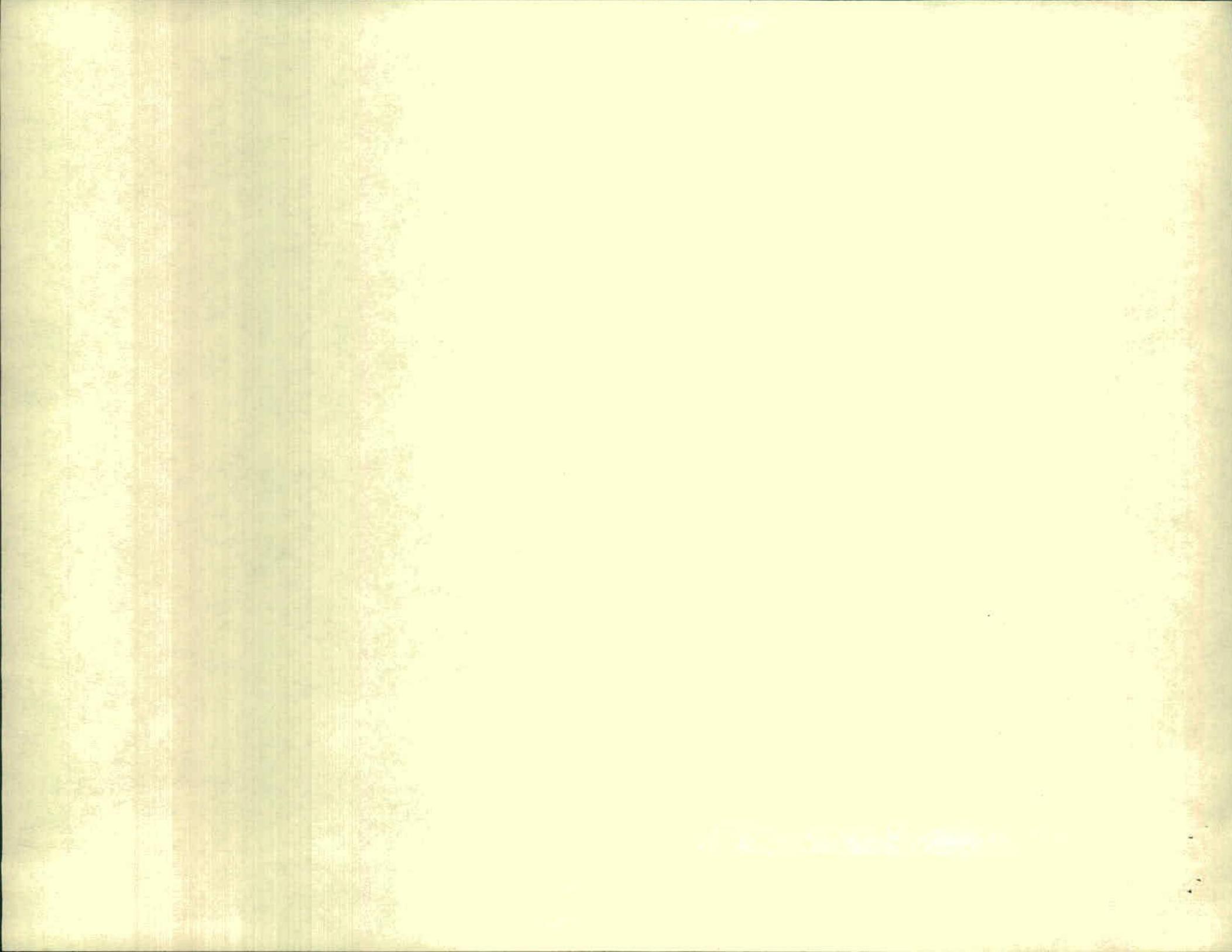
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01-05-07

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
90	90		REV. B
CHECKED	APPROVED	D3560	SHEET 3 OF 3
DATE	TITLE	ARM WELDMENT	SCALE
07.01.15			1:2



DART AEROSPACE LTD	Work Order:	32649
Description: A326	Part Number:	03560-1
Inspection Dwg: 03560 Rev: B		Page 1 of 1

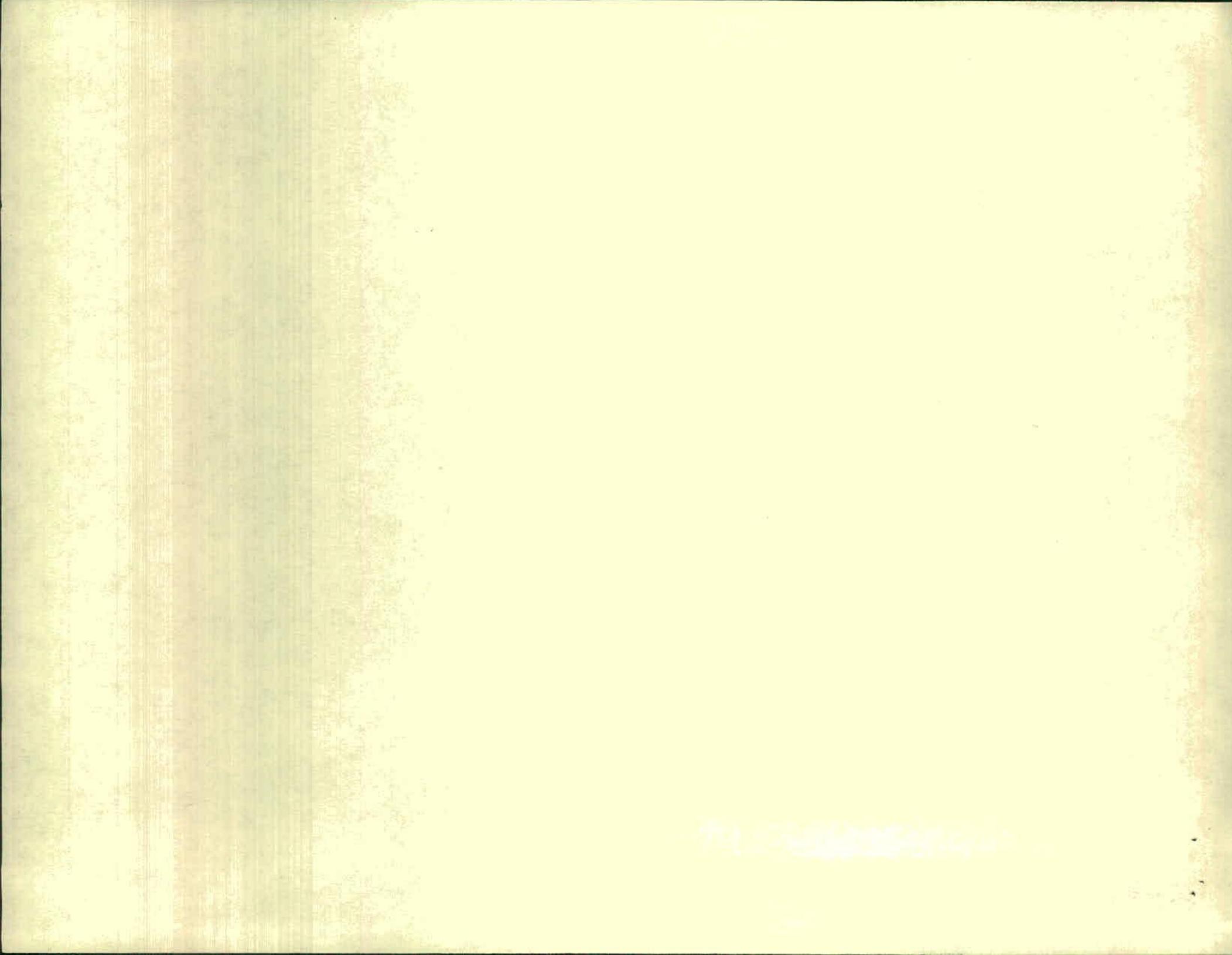
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.73	± .03	14.73	✓			
.9507	.0000 - .002	.957	✓			
.250	± .0010	.250	✓			
.188	"	.153	✓			
.250	"	.250	✓			
.275	"	.275	✓			
.2465	"	.2465	✓			
.12.682	"	.12.682	✓			
.14.73	± .03	14.73	✓			
.6031	± .010	.6031	✓			
.5.623	"	.5.623	✓			
.188	"	.188	✓			
.1032	"	.1032	✓			
.500	"	.500	✓			
.507	.0000 - .002	.507	✓			
.1046	.0000 - .001	.1046	✓			
.385 x .100"	± .010	.385	✓			
.01000	± .010	.01000	✓			
.2.000	"	.2.000	✓			
.1.000	"	.1.000	✓			
.325	"	.325	✓			
.12.13	± .03	.13	✓			
.850	± .010	.850	✓			

Measured by:	B6	Audited by:	JL	Prototype Approval:	JP
Date:	07/06/01	Date:	07/06/01	Date:	07/06/01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step-weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

